

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. G AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-698 REV. 7 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43
REF. FAA STC: SR01446NY
REF. EASA STC: EASA.IM.R.S.00709
REF. BRASIL STC: 2010S10-09
REF. CHINA VSTC0680

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide instructions to modify the D412-698-023 Automatic Door Opener Kit installation when installed on P/N DXXX-711-XXX Vertical Reference Door (ref. TCCA STC SH92-30/SH92-54/SH92-55/SH92-56, FAA STC SR00911NY/SR00937NY/SR00938NY/SR00939NY)

2.0 MODIFICATION TO D412-698-023 KIT INSTALLATION

The following sections of IIN-D412-698 should be modified as outlined below when installing the DSI 9788-011 Doubler Kit as part of the D412-698-023 Automatic Door Opener kit.

- 3.5.7 Remove the EA20469-21 Door Cover Panel from the inside of the door. Remove any existing rivets where the D5607-041/D3594-044 Doublers will be installed and remove the MS21069L3 anchor nut from the lower door frame as shown in Figure 2.
- 3.5.8 Locate the D5607-041 Doubler Assy on the door frame per Figure 2 of this DSI. Transfer drill 6x Ø0.129" (#30 drill) holes from the door frame to D5607-041 Doubler Assy. C'sink 3x vertical rivet holes on D5607-041 Doubler Assy for MS20426AD4 rivet. Transfer MS21071L3 anchor nut holes to D5607-041 Doubler Assy and the door frame using the existing screw hole as a guide. Transfer the Ø0.323" (P drill) hole from the D5607-041 Doubler Assy to the EA20469-21 Door Cover Panel for attachment of the D3622-1 Ball Stud.
- 3.5.10 Prime and paint the D5607-041/D3594-044 Doublers to match the aircraft per the Aircraft Maintenance Manual.
- 3.5.11 Apply a layer of Proseal on the faying surface of the D5607-041/D3594-044 Doublers. Install D5607-041 Doubler Assy using MS20426AD4 rivets as shown in Figure 2 of this DSI. Install D3594-044 Doubler using CR3242-4 or CR3243-4 rivets as shown in Figure 5 of IIN-D412-698. Install the MS21071L3 anchor nut behind the D5607-041 Doubler Assy using MS20426AD3 rivets.
- 3.5.12 Not applicable to this Service Instruction.
- 3.5.15 Reinstall the EA20469-21 Door Cover Panel. Install a D3622-1 Ball Stud and NAS1149D0516J washer on each of the D5607-041/D3594-044 Doublers as shown in Figure 2 of this DSI and Figure 5 of IIN-D412-698.

3.0 PARTS LIST

Qty -011	Part Number	Description
X	DSI 9788-011	DOOR OPENER DOUBLER KIT
1	D5607-041	DOUBLER ASSY
1	MS21071L3	ANCHOR NUT

4.0 WEIGHT AND BALANCE

This DSI has a negligible effect on Weight & Balance

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 17.10.17
CERT. NO.: SH92-43
ISSUE NO.: 5

APPROVED

A	NEW ISSUE	RF	17.10.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9788	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOOR OPENER DOUBLER KIT	NTS
DATE	17.10.17	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

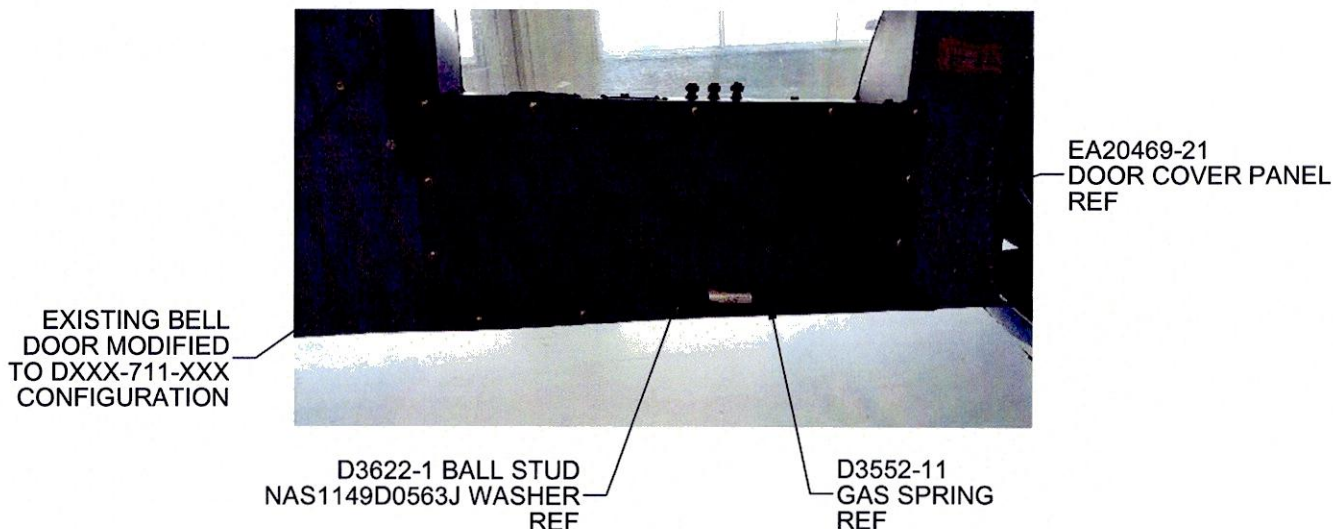


FIGURE 1: AUTOMATIC DOOR OPENER KIT
(LH INSTALLATION SHOWN)

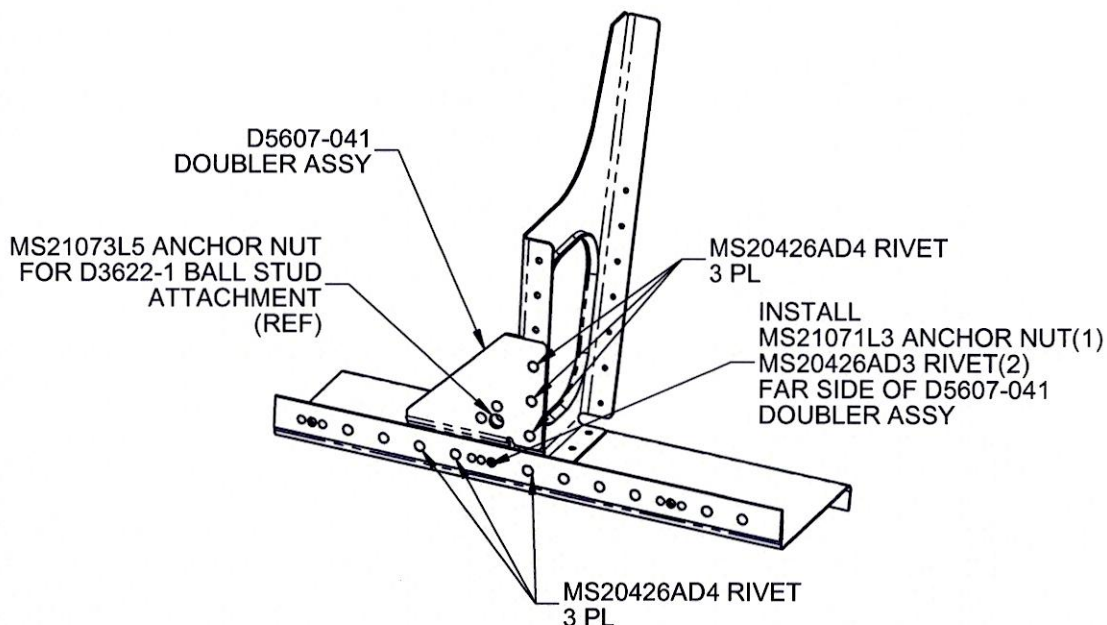


FIGURE 2: D5607-041 DOUBLER ASSY INSTALLATION
LOOKING AT INNER SKIN DOOR

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 17.10.17
CERT. NO.: SH92-43
ISSUE NO.: 5

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WK	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9788	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOOR OPENER DOUBLER KIT	NTS
DATE	17.10.17	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	